

Date: Tuesday, 5/23/2006 8:12:27 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L BASKET BASE
 Job Number : 27160A
 Estimate Number : 11273
 P.O. Number : N/A Part Number : D2252041
 This Issue : 5/23/2006 S.O. No. : N/A Drawing Number : D2252
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : E
 Previous Run : 26878A Material : N/A
 Due Date : 6/6/2006 Qty: 1 Um: Each
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06-01-23 W*
 Comment : Est Rev: I Revised as per Rev E 05-12-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31661 Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
5	D3166-1	Hoop	626717

PD 06-05-29

2.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: H100783

PD 06-05-29

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

PD 06-05-29

4.0 D22531 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2253	Gusset	B12413

PD 06-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:12:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 27160A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing B25823

PD

06-06-08

6.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chamel B26204

PD

06-06-08

7.0

D2254

Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2254 Lug B23421

PD

06-06-08

8.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 HINGE B24527

PD

06-06-08

9.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch

32 sf M304EX0.75-16F Expanded Metal H100981

PD

06-06-08

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Deburr as required

A/R SS ROD Batch: H100527

PD

06-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/23

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 27160A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/06/08

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/06/20

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/06/22

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

B27160

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/23

Job Completion



06/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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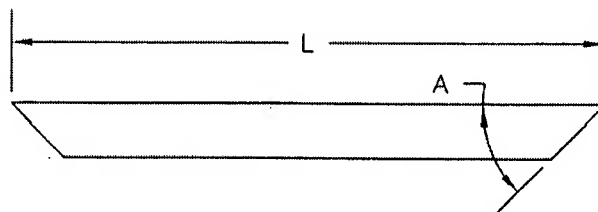
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DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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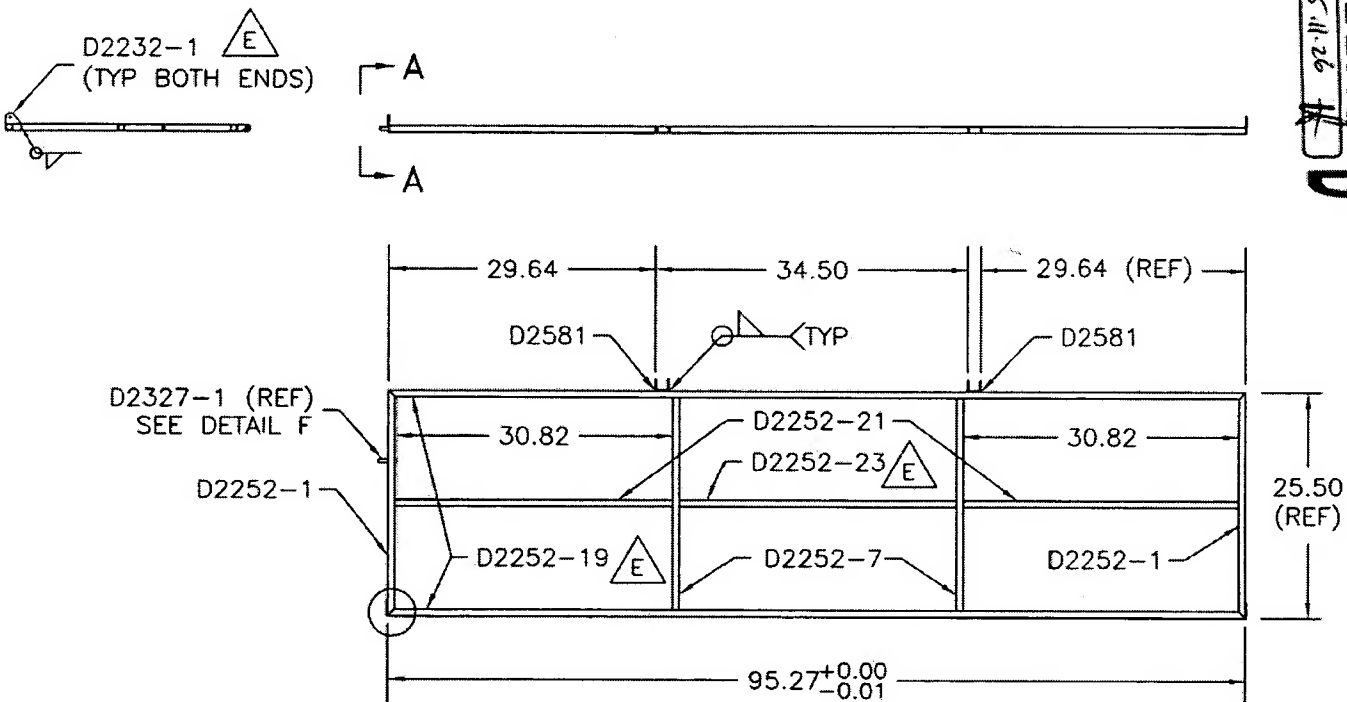
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DATE	05.11.10	TITLE	D2252	SHEET 2 OF 3
			BASKET ASSEMBLY (206L)	SCALE
				NTS

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D2252-043 LID FRAME

WELD ALL JOINTS
AS SHOWN

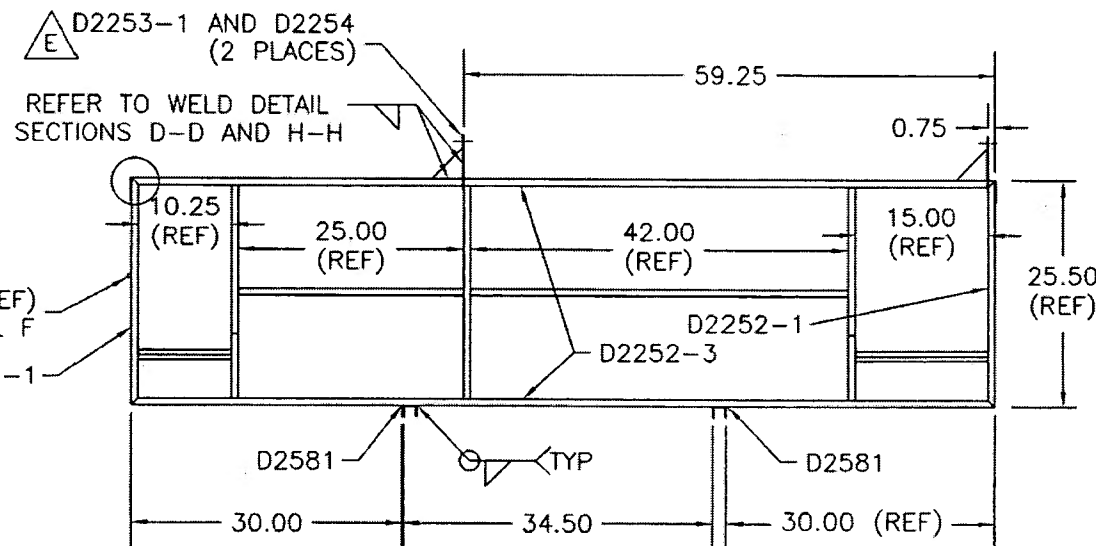
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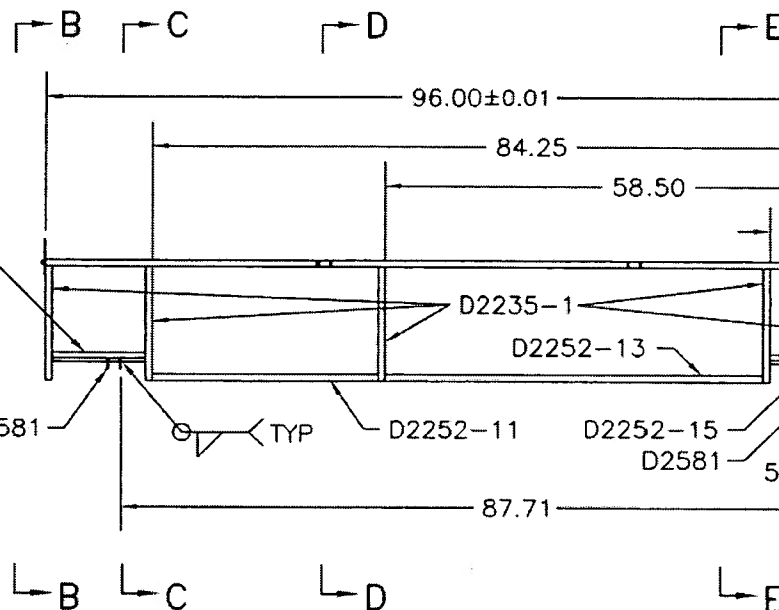
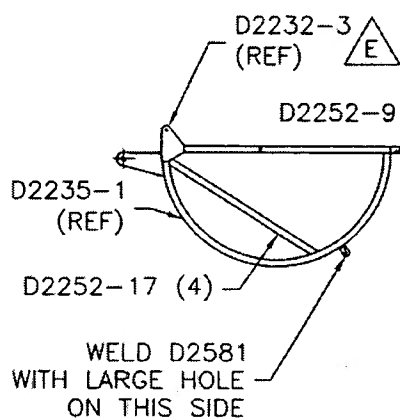
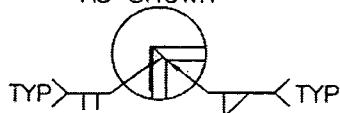
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DATE	05.11.10	TITLE	D2252	REV. E
			BASKET ASSEMBLY (206L)	SHEET 3 OF 5
				SCALE
				NTS



WELD ALL JOINTS
AS SHOWN



D2252-041 BASKET FRAME

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05/11/26

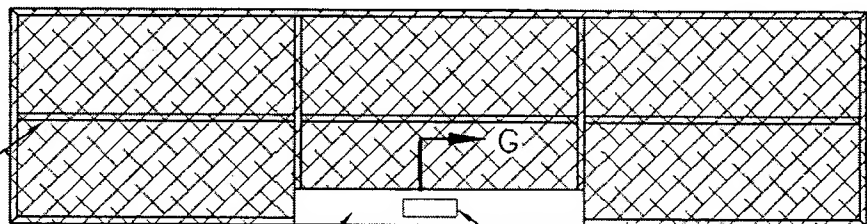
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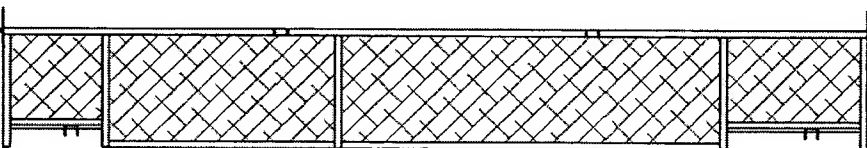
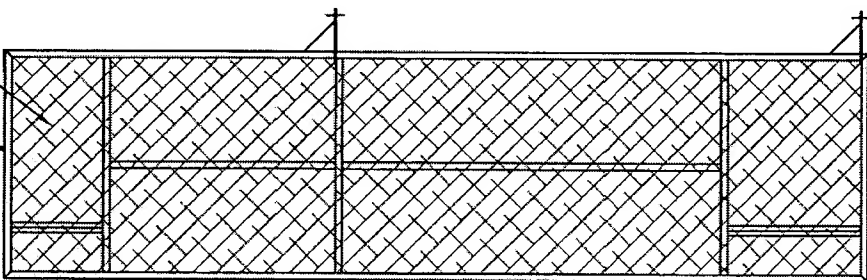
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DATE	05.11.10	DRAWING NO.	D2252	REV. E
		TITLE	BASKET ASSEMBLY (206L)	SHEET 4 OF 5
				SCALE
				NTS



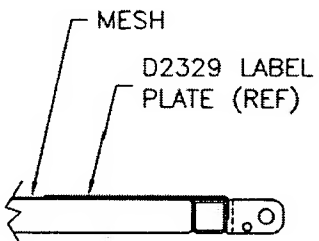
D2329 LABEL PLATE
CENTER ON THE
BASKET LID

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

D2252-043 LID ASSEMBLY



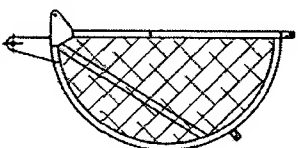
D2252-041 BASKET ASSEMBLY



SECTION G-G



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME

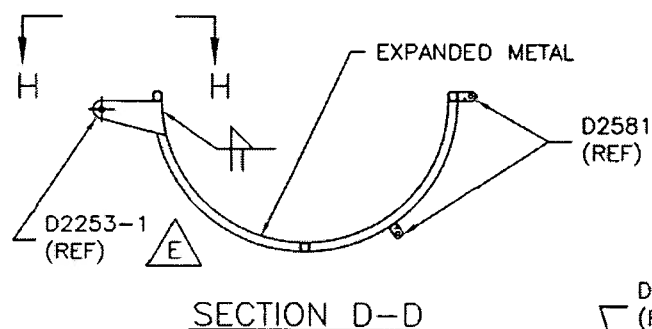
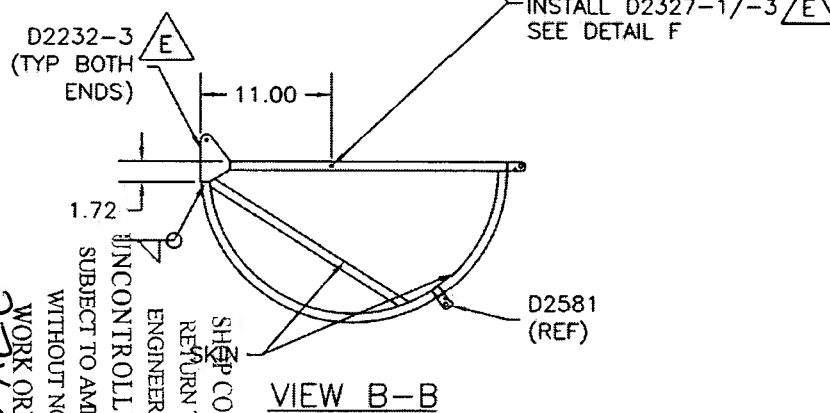
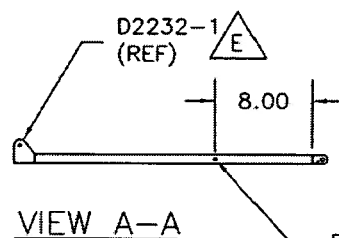
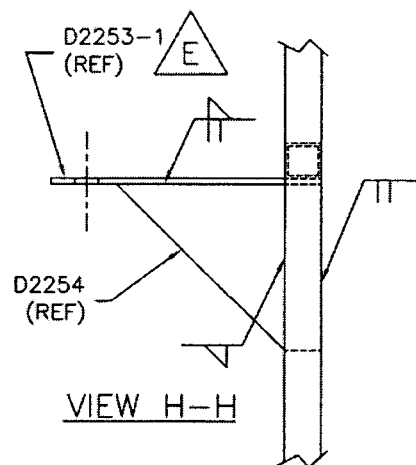
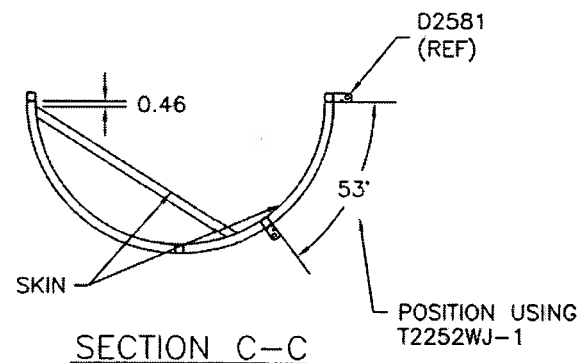
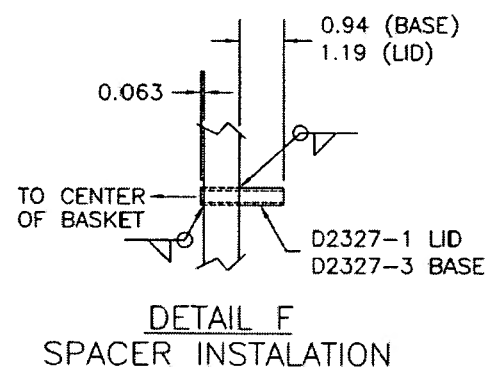
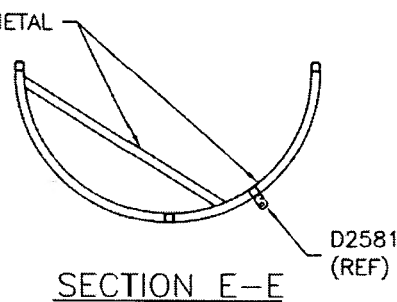


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DATE	05.11.10	DRAWING NO.	D2252	SHEET 5 OF 5
		TITLE	BASKET ASSEMBLY (206L)	SCALE
				NTS



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